

**Amendment to the Specification:**

On page 11, the paragraph beginning on line 10 has been amended as follows:

As used herein, the term "a flowable state" of a build material is a state wherein the material is unable to resist shear stresses that are induced by a dispensing device, such as those induced by an ink jet print head when dispensing the material, causing the material to move or flow. Preferably the flowable state of the build material is a liquid state, however the flowable state of the build material may also exhibit thixotropic-like properties. A material is in a flowable state when the temperature of the material is above the ~~materials~~ material's melting point. The term "solidified" and "solidifiable" as used herein refer to the phase change characteristics of a material where the material transitions from the flowable state to a non-flowable state. A "non-flowable state" of a build material is a state wherein the material is sufficiently self-supportive under its own weight so as to hold its own shape. A build material existing in a solid state, a gel state, a paste state, or a thixotropic state, are examples of a non-flowable state of a build material is a state wherein the material is sufficiently self-supportive under its own weight so as to hold its own shape. A build material existing in a solid state, a gel state, a paste state, or a thixotropic state, are examples of a non-flowable state of a build material for the purposes herein. A material is in a non-flowable state when the temperature of the material is below the material's freezing point. In addition, the term "cured" or "curable" refers to any polymerization reaction. Preferably the polymerization reaction is triggered by exposure to actinic radiation or thermal heat. Most preferably the polymerization reaction involves the cross-linking of monomers and oligomers initiated by exposure to actinic radiation in the ultraviolet or infrared wavelength band. Further, the term "cured state" refers to a material, or portion of a material, in which the polymerization reaction has substantially completed. It is to be appreciated that as a general matter the material can easily transition between the flowable and non-flowable state prior to being ~~cured~~ cured, however ~~However~~, once cured, the material cannot transition back to a flowable state and be dispensed by the apparatus.

On page 14, the paragraph beginning at line 17 has been amended as follows:

It is to be appreciated that the curable phase change build material formulations contain between about 5% to about 25% by weight of a non-reactive wax. In the preferred embodiment, the non-reactive wax content is between about 10% to about 12% by weight, and is comprised of a urethane wax. However, other non-reactive waxes could be used such as carbon hydrogenated waxes, paraffin waxes, fatty ester waxes, and the like. The wax content is necessary in order to provide the appropriate phase change characteristics of the build material so that the material would will solidify after being dispensed. This wax, which does not cure when exposed to actinic radiation, is trapped within the cured matrix of the polymerized reactive components of the build material formulation.

On page 17, the paragraph beginning at line 6 has been amended as follows:

It was theorized that the discoloration occurs due to thermal stresses resulting during part cooling causing the wax content that permeates the matrix of cured build material to migrate to regions of lower compressive stresses during post processing. The liquid wax is believed to move in capillary like fashion towards regions of the part which remain above the freezing point of the build material composition. As the part cools rapidly below the freezing point, generally below about 70° C, the external regions cool before the internal regions of the part. As the outer regions cool and contract faster than the inner regions, the wax component in the build material is believed to migrate towards the inner regions of the three-dimensional object, and the inner portions then solidify with a substantially higher volume percentage of the wax component. It is believed that this produces objects undesirably having transparent edges and opaque centers. It is believed the transparent edges of the objects are from where the wax content had migrated ~~from~~, and the opaque centers of the objects are to where the wax content had migrated ~~to~~.